

Ship Jan 31

Work Order ID 79384

79384

Page 1

Wednesday, January 25, 2012 11:49:14 AM

Item ID: D4436-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Aft Bracket Assembly
 Start Date: 1/25/2012 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 2/3/2012 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: [Signature] Date: 12-01-25 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4436	A								

100

0.00

100

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg and intall grommet

Sp 12/01/30

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

St 12/01/31

(70)

160

Identify as per dwg & Stock Location: 137

0.00

160

Packaging

Memo

0.00

Packaging

(12/01/31) (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79384***79384***

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Wednesday, January 25, 2012 11:49:15 AM

Item ID: D4436-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Bracket Assembly
Start Date: 1/25/2012 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 2/3/2012 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

12/2/11 [Signature]

CMF
12-01-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Wednesday, January 25, 2012 11:49:19 AM

Page 1

79384

D4436-041

Start Date: 1/25/2012

Required Date: 2/3/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 11.10.05 NEW ISSUE DD VERF:EC
RevB 11.12.22 per PA2 EC verified by:JLM
12.01.24 PER DWG REV.A DD VERF:EC

IPP
IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4440-1		Manufactured	No			100	Each	2.0000	1	1			
D4440-1									**			Sd 12/01/31	
Grommet								B 77917					
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				prelim				2					
					74759			2					
D4435-043		Manufactured	No			100	Each	1.0000	1	1			
D4435-043									**			Sd 12/01/31	
Mount Bracket Assembly													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ENG				1		B 79612			
					78249			1					
D4436-043		Manufactured	No			100	Each	1.0000	1	1			
D4436-043									**			Sd 12/01/31	
Aft Outboard Bracket Assembly													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ENG				1		B 79614			
					77908			1					
D4436-045		Manufactured	No			100	Each	0.0000	1	1			
D4436-045									**			Sd 12/01/31	
Aft Inboard Bracket Assembly								A 79613					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Wednesday, January 25, 2012 11:49:19 AM

Work Order ID: 79384

79384

Parent Item: D4436-041

D4436-041

Parent Item Name: Aft Bracket Assembly

Start Date: 1/25/2012

Required Date: 2/3/2012

Start Qty: 1.00

Required Qty: 1.00

AN525-832R6

Purchased

No

100

Each

44.0000

4

4

AN525-832R6

Screw

**

SB

12/01/31

Location

Loc Qty

Loc Code

ST345

20

120308

20

ST346

24

118612

24

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

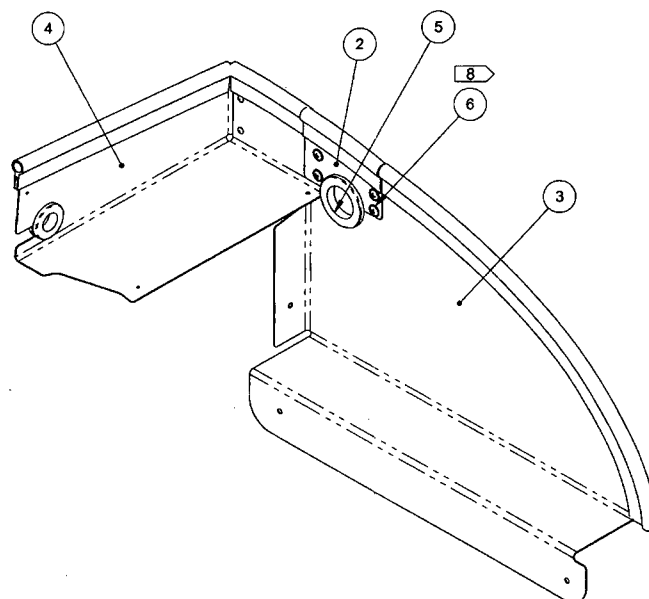
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4436-041	AFT BRACKET ASSEMBLY
2	1	D4435-043	BRACKET ASSEMBLY
3	1	D4436-043	AFT OUTBOARD BRACKET ASSEMBLY
4	1	D4436-045	AFT INBOARD BRACKET ASSEMBLY
5	1	D4440-1	GROMMET
6	4	AN525-832R6	SCREW



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO REVISION
WITHOUT NOTICE
WORK ORDER
NO. 79384

12-01-24

RELEASED
12 2012-01-23
MP

D4436-041 AFT BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.31 lbs
- 8) TORQUE SCREW TO 12-15 (in-lb)

A	NEW ISSUE	RF	12.01.17
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	12.01.17		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A
DRAWING NO.	D4436	SHEET 1 OF 7
TITLE	COVER ASSEMBLY	SCALE
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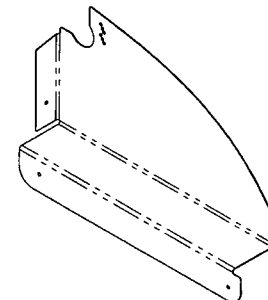
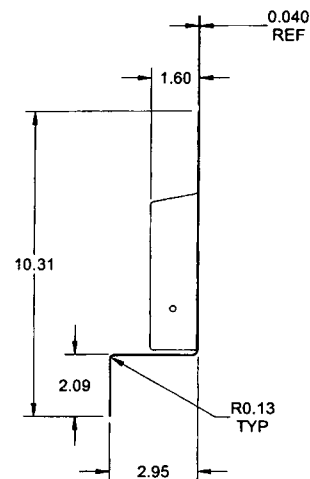
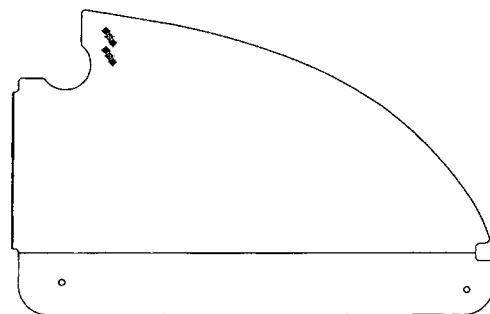
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4436-1 BRACKET

79384

RELEASE
2012-31-23

NOTES:

- 1) MATERIAL: MAKE FROM D4436-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.69 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4436	SHEET 4 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	COVER ASSEMBLY	NTS
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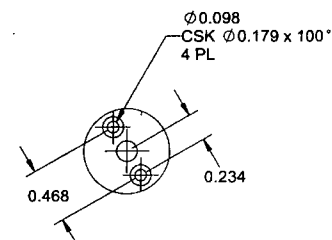
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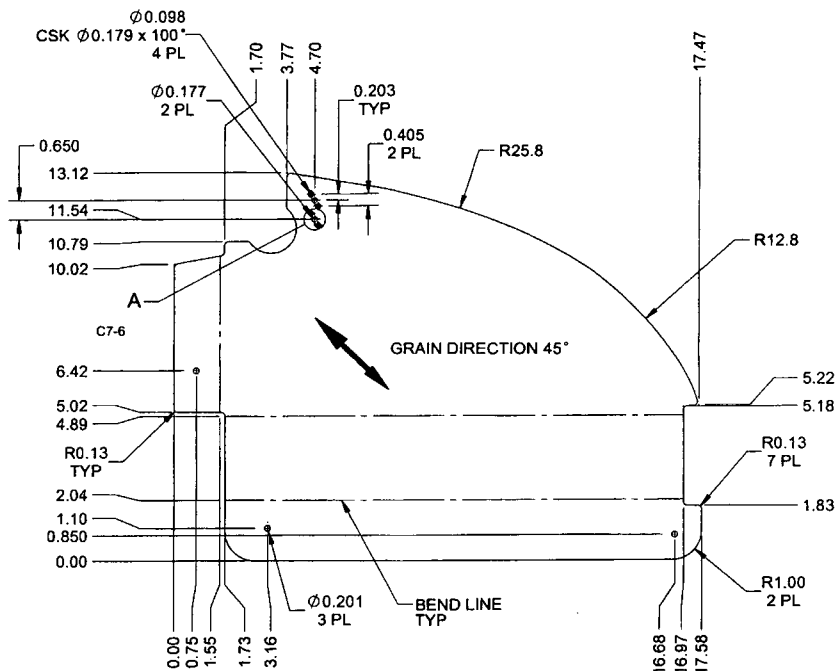
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NOTE: Date & initial all entries







DETAIL A C6-6
SCALE 4X, TYP



D4436-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.69 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4436	SHEET 5 OF 7
APPROVED		TITLE	SCALE
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RELEASED
2012-07-23
[Signature]

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